DART AEROSPACE LTD	Work Order:	23349
Description: Hi – Step Leg Assembly	Part Number:	D3065-041
Dwg: D3065 Rev. A1 .42	Qtv:	180 56
PF 05.02.17 PF03.02.28		Page 1 of 2

Step	Location	Procedure	By	Date	Qty
. 1 .	DC	Issue Traveller Dwg. not required RF 02.11.04	TAL		60
	100	(Minimum lots of 30)	Y Y	05.05.20	100
2	MV	Cut blanks: 3.600" x 4.500" (grain along 4.500") Ma\le 75 Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick of 03065	ا ا		
		(M2024T3S.040)  Batch  Maid Hall 2024-13 Sheet (QQ-A-250/4) 0.040 till ckor 1/2025	7		
ŧ		Identify as D3065-1 4.320" RF 02.11.25" 4.320"	136	05.08.06	75
3	MV	Cut blanks: 6.600" x 4.250" (grain along 4.320") +2.50") ***	150	05.08.06	1/3
Ū		Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick	a_		
		(M2024T3S.040)  Batch M17949		-	
		Identify as D3065-3	136	1 -1	60
4	MV	Cut blanks: 4.580" x 4.500" (grain along 4.500")	130	65.04.07	10,
•		Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick			
		(M2024T3S.040)  Batch M17948			1
		Identify as D3065-7	136		160
5	MV	Cut blanks: 16.61" x 8.51" (grain along 8.51") for each leg.	136	05.08.06	60
J	****	Material: 5052-H32 Sheet (QQ-A-250/8) 0.080" thick			
	1				
		Library Dodger	15	SEN 2	
	-	Identify as D3065-5	100	05.06.20	120
6	MV		ļ		
	1010	Cut blanks: 16.490" x 0.750" for each spacer. (-0.00/+0.010)			
		Material: 5052-H32 Sheet (QQ-A-250/8) 0.080" thick			
	•	(M5052H32S.080) Batch <u>M; 76</u> 9 5	EV		120
			27	03.06.20	430
7	MV	(Note: make 2 spacers per assembly)	ļ	3.23	7
,	IVIV	Machine D3065-1 as per folio FA182 and Dwg D3065, use	21		_
8	MV	stack of 15.	136	05.08.04	.75
0	IVIV	Deburr to take measurement	L-	1	
9	QC2	language and the second	136	05.08.09	-75
9	QC2	Inspect parts as they come off the CNC machine			
10	QC8	Coond shook	136	65.68.04D	75
10	QCo	Second check			-ز -
11	MV	Machina D2065 2 on nonfelia FA400 and D D2005	P	05/08/07	- 13
11	IVIV	Machine D3065-3 as per folio FA180 and Dwg D3065, use	ر جب ا		
12	MV	stack of 15.	136	05.04.07	60
12	IVI V	Deburr to take measurement	77	]	
12	000	Inspect parts on the control of the	136	05.08.07	6 D
13	QC2	Inspect parts as they come off the CNC machine			/-
11	000	Cocond shoots	136	05.08.07	60
14	QC8	Second check	2	ابدرا	
15	NA\/	Marking DOOG 7	OP	05/28/08	60
15	MV	Machine D3065-7 as per folio FA181 and Dwg D3065, use	_		,
10	8.00 /	stack of 15.	736	e5.08.08	60
16	MV	Deburr to take measurement	_		3
47	000		136	o5.08.08	<u> 60</u>
17	QC2	Inspect parts as they come off the CNC machine			_
<del></del> _	000		134	05.08.08	60
18	QC8	Second check		, .T	
	1011		6	05/08/08	60
19	MY/	Machine D3065-5 as per folio FA1/79 and Dwg/D3065, use			
' I		stack of 10.		/ /	/

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W/O:	P. S.	WORK ORDER CHANGES	<del> </del>				,
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
***		<b>发放</b>			•		
	3		-				•
- Company				*			

NCR:		W	WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section B		Verification	Approvial	Approval	
DATE	STEP	Section A	Initial Design Mgr	Action Description  Design Mgr	Sign & Date	Section C	Approval Design Mgr	Approval QC Inspector	
05.69.68	31	12x D3065-041 ASSEMBLES ARE SCRAP, Deep dramage and distor- tion from riveling.	OFFICE	SCYAP & Clestroy Center step spacers are bentistep legs, too much time to drillout rivets.	SB 05/07/08	05-09-08	AB OSDIT	05.09.08	

	•				
Part No:	PAR #:	Fault Category:	NCR:	Yes No DQA:	Date: <u>QS /09 /13</u>
	,		*		- V. V. V.
NOTE: Date & initial all entries				QA: N/C Closed:	Date:

DART AEROSPACE LTD	Work Order:	23349
ř		
Description: Hi – Step Leg Assembly	Part Number:	D3065-041
Rf 03,02,28		
Dwg: D3065 Rev. At A2	Qty:	100
PF 03-03-17	Q.y.	Page 2 of 2

Step	Location	Procedure			T
19	MV	Machine D3065-5 as per folio FA179 and Dwg D3065, use	By	Date	Qty
		stack of 10.	1/2/	000000	1.7.
20	MV	Deburr to take measurement	730	08.06.20	120
-	1		120	03.06,20	170
21	QC2	Inspect parts as they come off the CNC machine		1	
22	QC8	Second check	30	05.06.20	(10
23	MV	Machine D3066-1 as per Folio FA280 and Dwg D3066, use stack of 10.	2 N		
24	MV	Deburr to take measurement	20	05.06.20	120
25	000		22	05.06.20	120
25	QC2	Inspect parts as they come off the CNC machine	_		
26	QC8	Second check	70	05.06,20	120
	QUU	Second crieck	Since	05/06/21	
27	GA	Deburr D3065-1, D3065-3, D3065-5, D3065-7 & D3066-1	SAO	05/06/21	26
		_ stack.		05.08.11	120
28	GB	Bend D3065-1, D3065-3 & D3065-7 as per Dwg D3065			
29	QC5	Inspect work to Step 28	$\angle$	05.08.14	120
		300 20	<n td=""  <=""><td>X108/14</td><td></td></n>	X108/14	
30	FP	Chemical conversion coat as per QSI 005 4.11 Rf 02.11.06	-		
		D3065-1, D3065-3, D3065-5, D3065-7-& D3066-1	77	05.0827	120
31	GA	Assemble as per Dwg D3065 and identify as D3065-041	-		
		Assembly.			
		Qty Part Number Description Batch	· t	j	
		1 D3065-1 Spacer 623341 B22955		اماما	
		1 D3065-3 Spacer \$ 23244 B22959	cal	05/09/08	56
	·	2 D3065-5 Leg 3 3 3 4 9 2 2 7 5 9	<i>30</i> ∣		
- 1		Spacer 18 3 5 (1 / 5 / 2 / 5 / 5 / 5 / 5 / 5 / 5 / 5 / 5			. ]
		30 MS20470AD4-A Rivet MILIES MITTARY H 1.6/99	ľ	` '	
32	QC5	Inspect work to Step 31			
				5-05-12	56
33	GA	Identify and Stock	,	₹,	
	ļ	D3065-041 Hi-Step Leg Assembly	PD	200	
34	AC	D3066-1 Spacer	Ln (	25-09-13	56
		Cost / part 44.67	م سرمه ک	J-05.13	
35	DC	Close W/O 40.77			
		Inspect Level 21		35/08/13 E	56
			<del></del>		حرو

Rev	Date	Change	Revised By	Approved
Α	01.12.10	New Issue	SM	Approved
В	02.09.10	Re-format; Incorporated D3065-1/-3/-5/-7	KJ	
С	02.11.01	Incorporated D3066-1 IPP	KJ R	



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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGE	CHANGES						
DATE	STEP PROCEDURE CHANGE			Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		W	ORK OR	DER NON-CONFORMANCE	(NCR)			
DATE	OTED	Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE STEP		Section A	Initial   Action Description   Sig   Design Mgr   Design Mgr   Design Mgr   Description   Descript			Section C	Design Mgr	QC Inspector
05/08/23	28	D3065-3 pieces are old under Toterance		Acceptable, will modify Sig. DT 8174 to avoid the under tolerance		05-08-23		05-06-23
05/08/23		piece was snap		Screp + destroy	SB 05/08/23	a: 06.23		4413
05/08/12	27	1 pièce was Enep D 3065-5		Sorgo + destroy	SB U5/08/23	05.08.23		W-08.23

Part No:	PAR #:	Fault Category:	NCR:	Yes	No	DQA:	 Date:
NOTE: Date & initial all entries			**	QA: N	I/C C	losed:	 Date:

D3065-5DART AEROSPACI	E LTD	Work Order:	23349
Description: Step Spacer		Part Number:	D3065-1
Inspection Dwg: D3065 Rev	v: A2		Page 1 of 1

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	0. 249				
2.093	+/-0.010	2.092				
3.936	+/-0.010	3.535				
4.186	+/-0.010	4.186	_			
0.587	+/-0.010	0.508	-			
Ø0.128	+0.005	0.128	_			
R0.125	+/-0.010	0.125		į.		·
3.465	+/-0.010	3.463	-			
Ø1.250	+0.005 -0.000	1,250	_			
0.368	+/-0.010	0.368				
0.871 (Pitch)	+/-0.005	6.870				
		·				
7 - 7 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 -						
	-					

Measured by:	Er-	Audited by:	and	Prototype Approval:	N/A
Date:	05/08/07	Date:	05/08/07	Date:	03.10.08

Rev	Date	Change		Revised by	Approved
A	03.09.22	New Issue	P/O D3065-041	KJ/RF	72



D3065-5DART AEROSPACE LTD	Work Order:	23349
Description: Step Spacer	Part Number:	D3065-3
Inspection Dwg: D3065 Rev: A2		Page 1 of 1

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.260	+/-0.010	1.257	_			
3.260	+/-0.010	3.257				
5.260	+/-0.010	5.256	-			
6.520	+/-0.010	6.520				
2.093	+/-0.010	7.089				
3.936	+/-0.010	3.935				
4.186	+/-0.010	4.186				
Ø0.128	+0.005/-0.000	.130				
Ø1.250	+0.005/-0.000	1.250	_			
Pitch 1.204	+/-0.005	1.204				
					,	
<del></del>						

Measured by:	86	Audited by:	Es	Prototype Approval:	N/A
Date:	05.08.0 <b>4</b>	Date:	05/08/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.02.25	New Issue P/O D3065-041	KJ/RF	2/
В	04.08.12	Removed dimension 1.204	KJ/JLM	12011
-				7

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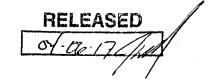
D3065-5DART AEROSPACE LTD	Work Order:	23349
Description: Step Leg	Part Number:	D3065-5
Inspection Dwg: D3065 Rev: A2		Page 1 of 1

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.458	+/-0.010	16.938				
15.750	+/-0.005	15.730				· ·
2.250	+/-0.005	2,280	/			
3.460	+/-0.005	3,459				
0.865	+/-0.005	.865	/			
6.020	+/-0.005	6.019			-	
1.205	+/-0.005	1.203				
3.484	+/-0.005	3.484	/			
0.871	+/-0.005	.871				
8.325	+/-0.010	7.326	'/			
0.551	+/-0.010	-553				
0.213	+0.005/-0.000	.2/3	/			
Ø0.128	+0.005/-0.000	0,128		•		
						-
,					·	
	·					

Measured by:	22	Audited by:	F3	Prototype Approval:	N/A
Date:	06.20.20	Date:	05.06.20	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	03.09.22	New Issue	P/O D3065-041	KJ/RF	21
В	04.06.15	Added Ø0.128	dimension	KJ/JLM	C RIII



D3065-5DART AEROSPACE LTD	Work Order:	23349	
Description: Step Spacer		Part Nümber:	D3065-7
Inspection Dwg: D3065 Rev: A2			Page 1 of 1

X First Article Prototype

· · · · · · · · · · · · · · · · · · ·						
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.000	.130	-			
0.865 (Pitch)	+/-0.005	. 867	/			
4.522	+/-0.010	4.570	-			
0.250	+/-0.010	.750				
2.093	+/-0.010	7.093				
3.936	+/-0.005	3.935				
4.186	+/-0.010	4.185				
Ø1.250	+/-0.005	.1.750				
R0.125	+/-0.010	.125	-			
Grain Direction	N/A	/				
					***	
	·					
						,

Measured by:	Audited by:	En	Prototype Approval:	N/A
Date: 65.08.07	Date:	05/08/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.09.22	New Issue P/O D3065-041	KJ/RF	0/
В	04.05.15	Removed 0.531, 3.686, 0.580; Added 3.936 dimensions	KJ/JLM	

RELEASED ( ) Selfort on 27.

D3065-5DART AEROSPACE LTD	Work Order:	23349	
Description: Spacer	Part Number:	D3066-1	
Inspection Dwg: D3066 Rev: A		Page 1 of 1	

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005 -0.000	132				
0.708	+/-0.010	.701				
0.358	+/0.010	- 360				
0.350	+/0.010	,351				
2.250 (Pitch)	+/-0.005	2.250				
16.450	+/0.010	16.450				
,						
	,					
				,		

Measured by:	2.2	Audited by:	·ME	Prototype Approval:	N/A
Date:	05.06.20	Date:	05/06/21	Date:	03, 10.08

Rev	Date	Change		Revised by	Approved
Α	03.09.22	New Issue	P/o .D3065-041	KJ/RF	



#### Job Costing Report

Dart Aerospace Ltd. Hawkesbury

May 17, 2005 10:51 am

Work Order No : 0023349

Project Name : D3065-041
Project For : WK532

Work Order Type : Main Main WO Number :

House Part Number: D3065-041 Description : Step Leg Assembly

Manufactured: Yes

Amount Req'd: 60

Amount Done: 0

Start Date: 05-17-05 Start Date

Est Finish Date : 06-30-05

Act Finish Date : Drawings Reqd : No

Ok for Approval :

Approval Rec'd :

Department Code:

Burden Flags : NNNNNNN

WO Status : Open

Invoice State : Not Invoiced

Invoice Date :

Invoice Number :

Invoice Amount: 0.00

Order Entry No:

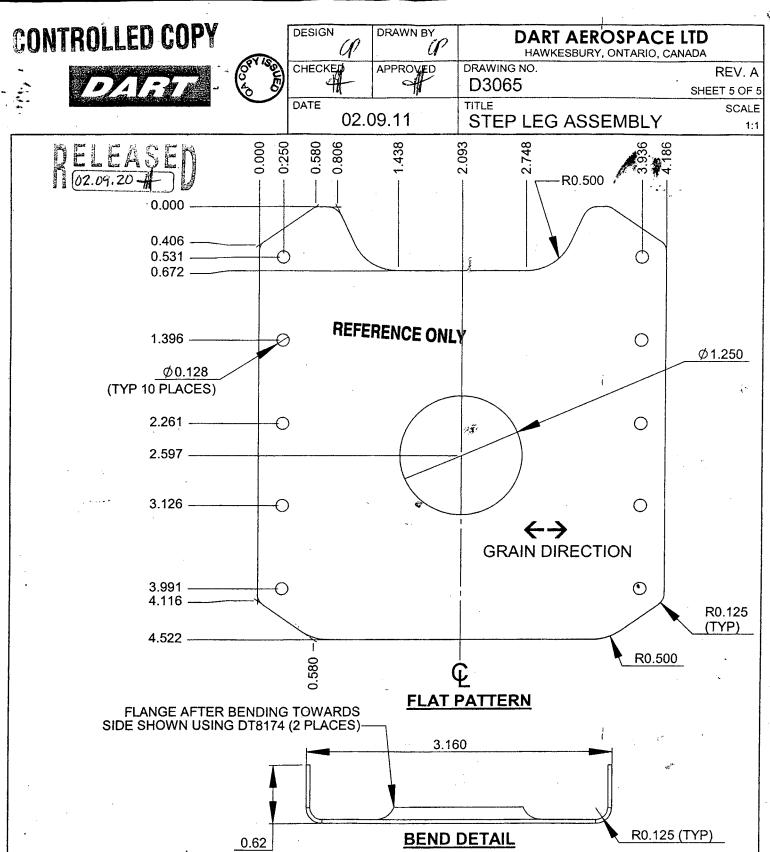
OE Value : 0.00

Est Mark Up : 0.000% Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

		Estimated	Actual	Var. %	Posted	To Post
Material Cost	:	0.00	0.00	0.00	.0.00	0.00
Engineering Hours Engineering Cost	: :	0.00 0.00	0.00	0.00	0.00	0.00
Production Hours Production Cost	:	0.00	0.00	0.00 0.00	0.00	0.00
Packaging Hours Packaging Cost	:	0.00	0.00	0.00	0.00	
OverHead Hours	:	0.00	0.00	0.00		0.00
'OverHead Cost CNC Hours	:	0.00 0.00	0.00	0.00 0.00	0.00	0.00
CNC Misc. Hours	:	0.00	0.00	0.00	0.00	0.00
Misc.	:	0.00	0.00	0.00	0.00	0.00
Burden	:	0.00	0.00	0.00		
Total Cost Mark up Selling Cost	:	0.00	0.00	0.00		
-						

Estimated Actual Labour Hrs/Amount Done : 0.00 0.00 Profits/(Loss) 0.00 0.00



## D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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